

54322 Blue

Work Order ID 53293 DeRev



October 30, 2009 1:16:12 PM

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: 09-10-30 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A *[Signature]*

# Work Order ID 53293

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Item ID: D206-642-441  
Revision ID: F  
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 29/10/2009 Start Qty: 1.00  
Required Date: 09/11/2009 Req'd Qty: 1.00



Cust Item ID:  
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110



Skidtubes

Skidtubes

0.00

0.00

## Memo

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod M112507/M111988 *BC 9-11-3*

4-Grind weld flush to cap on top surface only. *BC 9-11-3*

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

*9-11-3*

*9-11-3*

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Cust Item ID:

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Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
	Skidtubes								
	QC5								
	Memo	0.00							
	Install D2680-041 Nut plate as per Dwg								
	AD								
130	QC10- Inspect visual per QSI004- ground welds	0.00							
	QC								
	Memo	0.00							
	Quality Control								

11/09/11/03 - Chemical conversion - AWM 9-11-3 - ①

- QC 3 DP 9-11-3

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Item ID: D206-642-441

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Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail  
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.  
cure time before cuttingStart Date: 9-11-03 Time: 3 PMFinish Date: 9-11-04 Time: 8:30 AMA/R ☐ Sikaflex-291 ☐Sikaflex expiry date: 10-02-20

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2ND FROM PWD

# Work Order ID 53293

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Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R ☐ Aluminum Rod M112507 BE 9-11-04

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburf

n 9/11/06

165

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo


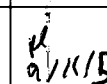
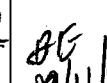

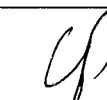


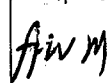



0.00

Quality Control

N/A 09/11/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-441 PAR #: N/A Fault Category: Skid tubes NCR: Yes No DQA: ll Date: 09-12-08  
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: ll Date: 05-12-11

NCR: 53293		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/11/05	#160	Drilling * counter boring <del>at</del> the counter bore holes and cracks the <del>to</del> x-bolt spacer. R.C. process	 09.11.05 per 09/11/05	- Drill out and x-bolt from FWD - Re weld new D2649 B*47112 Qty x1	 9/11/05  09/11/05	 09/11/05	 09.11.05	 09/11/05
			 09.11.05 per 09/11/05	- Grind weld flush and <del>contam</del> component remain task on w/o	 9-11-06	 09/11/06	 09.11.05	 09/11/05

NOTE: Date & initial all entries

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Item ID: D206-642-441

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Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

170

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D2650

1 - - AWM 9-11-06

180

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

=> Sosluloc

(H)

f

190

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

=> Sosluloc

(H)

f

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Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Pressure Wash per QSI005 4.3	0.00							
	HandFinish	0.00							
Hand Finishing	+ Touch up Alodine Memo	0.00							
205	Spray Painting per QSI005 4.2	0.00							
	SprayPaint	0.00							
Spray Painting	Memo PRIME GREY 110918 SPRAY PAINT DELFLEET BLUE 110077 CLEAR DELFLEET 113088	0.00							
215	QC14- Inspect Spray Paint	0.00							
	QC	0.00							
Quality Control	Memo	0.00							

(X)

09 11 11

09 11 11

09 11 11

09 11 11

09 11 11

09 11 11

09 11 12

09 11 12

09 11 12

09 11 12



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Item ID: D206-642-441

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Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☐ *M112391*

Sikaflex expiry date: ☐ *10/01*

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☐ *M112391*

Sikaflex expiry date: ☐ *10/01*

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch *M112623*

*10-11-17*

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Item ID: D206-642-441

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Setup Start



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Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
250	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-441								
	Location: <u>PPD</u>								
	PPP Rev: <u>53223</u>								
260	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

27502/10/28

④

09/12/08

09/12/08

UMF 09-12-07

# Picklist Print

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Work Order ID: 53293



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2620RevB		Manufactured	No			110	Each	13.0000	1.0000			
-----------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Skidtube, 206 Skidtube

*Handwritten:* 9-11-3

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

13

45898

13

D2646RevC

Manufactured No



Aft Cap

120	Each	44.0000	1.0000
-----	------	---------	--------



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

44

20208

0

43801

1

46327

4

48109

39

D2647RevF

Manufactured No



Cap

140	Each	23.0000	1.0000
-----	------	---------	--------



*Handwritten:* 1 BR 09-11-17.

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

23

10773

7

43846

16

*Handwritten:* 1 BF 9-11-3

# Picklist Print

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Work Order ID: 53293



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2654-7RevE1		Manufactured	No			160	Each	2.0000	1.0000			
Web												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FG	2	
52801	2	

B-52917 \* AWM 9-11-03

CCR264SS3-3

Purchased

No

170

Each

65.0000

2.0000



Cherry Rivet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	65	
111548	38	
111827	1	
112314	26	

AWM 9-11-06

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Shop Packet Print

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Work Order ID: 53293



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			170	Each	476.0000	23.0000			
Cross Bolt Spacer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	83	
51529	83	
Main Warehouse		
ST	393	
36013	5	
47112	382	
48271	6	

23 BB 09-11-04

D2680-041RevB1

Manufactured No

170

Each

75.0000

1.0000



Nut Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	75	
33061	10	
44086	65	

- ALM 9-11-06

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Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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ALS4-1032-130		Purchased	No			230	Each	5,073.000	60.0000			
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Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5073

110511 ✓

5073

AN960JD10L

AN960C10L

Purchased

No

230

Each

5,735.000

62.0000



Washer

9/09/11/12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5735

101291

16

104885

153

105793

236

109632 ✓

420

110985

4910

AN960JD10L

60 09-11-17

PTD

2 09-11-17

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W/O: 53293		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.11.12	230	Qty (60) AN960 JD10L REPLACED WITH Qty (60) AN960 C10L M 112612	BR	09-11-17	60	09.11.12 BSI WZ	

Part No: D206-642-441 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD416

Purchased

No

230

Each

4,591.000

1.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4591

108161

519

110523

340

111279

101

111916

482

112314 ✓

3149

16941

0

CR3212-4-03

Purchased

No

230

Each

292.0000

2.0000



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

292

111359

92

112314

200

1 09-11-17

AWM 9-11-06 (2)



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Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2651-1RevB		Manufactured	No			230	Each	359.0000	22.0000			

Plug

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST 53314	359	
43990	81	
45490	28	
51530	250	

22 09-11-17.

D2651-3RevB

Manufactured No

230

Each

991.0000

22.0000



O-Ring

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	991	
43849	3	
46114 ✓	988	

22 09-11-17.

# Picklist Print

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Work Order ID: 53293

Parent Item: D206-642-441RevF

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 29/10/2009

Required Date: 09/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-15RevB		Manufactured	No			230	Each	22.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	17	
51671	17	
Main Warehouse		
ST	5	
30750	4	
42233	1	

1 17 09-11-17.

D3535-23RevB

Manufactured No

230

Each

15.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	13	
51618	13	
Main Warehouse		
ST	2	
48156	2	

1 13 09-11-17.

# Picklist Print

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Work Order ID: 53293



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-37RevB		Manufactured	No			230	Each	18.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	13	
51654 ✓	13	
Main Warehouse		
ST	5	
47374	5	

1 BL09-11-17

D3536-15RevA

Manufactured No

230

Each

32.0000

1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	32	
48159	6	
51600 ✓	26	

1 BL09-11-17

# Picklist Print

Page 9

October 30, 2009 1:16:19 PM

Work Order ID: 53293



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3536-23RevA

Manufactured

No

230

Each

21.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

12

51609 ✓

12

Main Warehouse

ST

9

30754

1

47713

8

D3536-37RevA

Manufactured

No

230

Each

20.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20

47375

7

51641 ✓

13

1 BL 09-11-17.

1 BL 09-11-17.

# Picklist Print

October 30, 2009 1:16:19 PM

Work Order ID: 53293

Parent Item: D206-642-441RevF

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 29/10/2009

Required Date: 09/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty/To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3537-1RevC

Manufactured

No

230

Each

299.0000

6.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

2

48288

2

Main Warehouse

FP17

297

51624 ✓

30

51678 ✓

162

51679

105

6 09-11-17

D3537-3RevC

Manufactured

No

230

Each

60.0000

1.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

60

30758 ✓

7

33881 ✓

17

35697

36

1 09-11-17

# Picklist Print

October 30, 2009 1:16:19 PM

Work Order ID: 53293

Parent Item: D206-642-441RevF

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 29/10/2009

Required Date: 09/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS27039-1-08 Purchased

No

230

Each

2,947.000

2.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2947

110467 ✓

188

110552

759

110835

2000

2 BL 09-11-17

MS27039-4-06 Purchased

No

230

Each

75.0000

1.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

75

109061 ✓

75

1 BL 09-11-17

MS27039C1-08 Purchased

No

230

Each

962.0000

60.0000



SCREW

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

962

19185 ✓

962

60 BL 09-11-17

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F



# NOTES:

MATERIAL: N/A  
FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.005 TO 0.010 MAX

IDENTIFICATION: NONE

WEIGHT: N/A

WELD PER DART QSI 004

DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015

) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.

) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

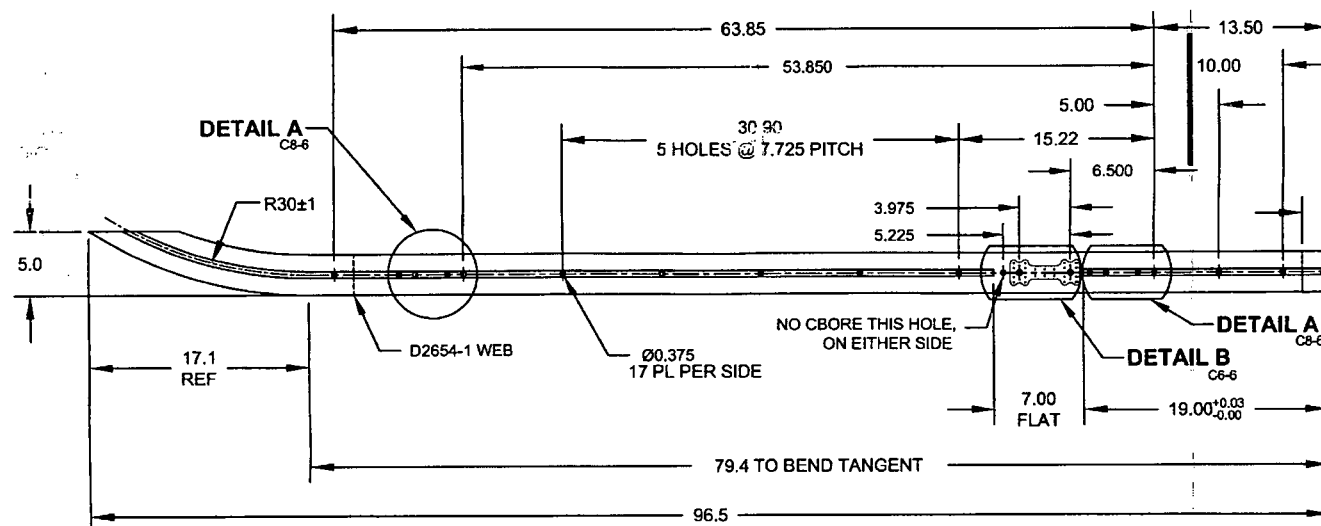
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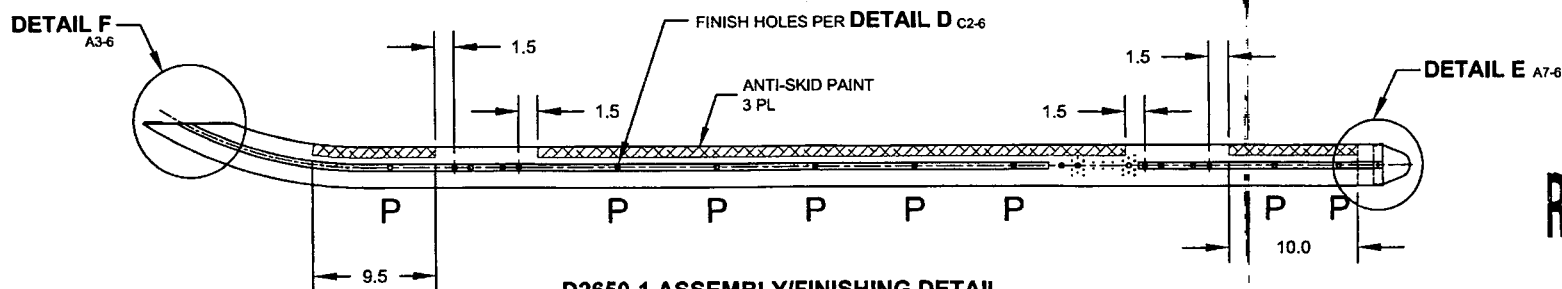
RELEASED  
08-07-23

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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**D2650-1 BENDING/DRILLING DETAIL**

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**D2650-1 ASSEMBLY/FINISHING DETAIL**

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68 09 22 / 114

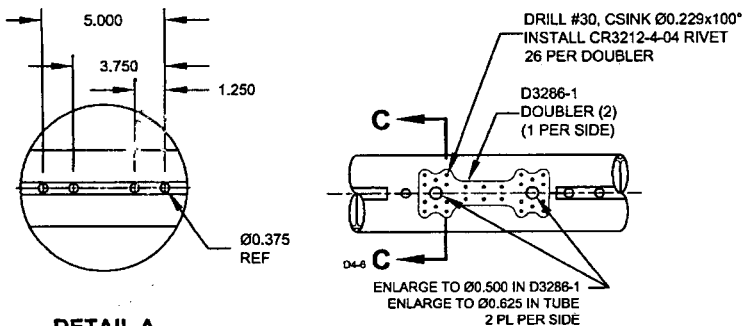
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MFG. APPR.		D2650	SHEET 2 OF 6
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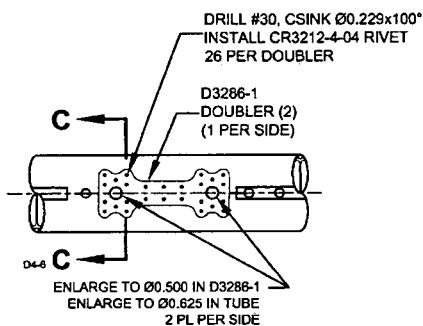




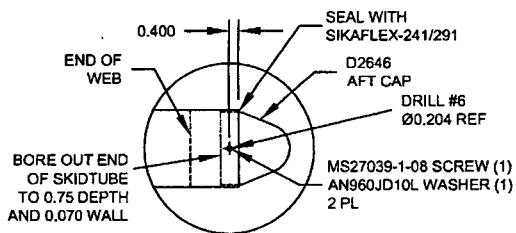




**DETAIL A**  
SCALE 2X  
C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D6-5

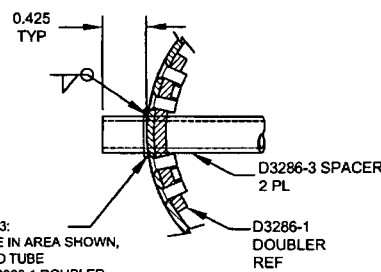


**DETAIL B**  
SCALE 2X  
C3-2  
C3-3

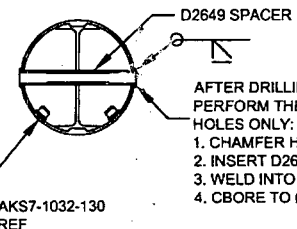


**DETAIL E**  
SCALE 2X  
B2-2  
B2-3  
B1-4  
B1-5

**SECTION C-C** C7-6  
SCALE NONE

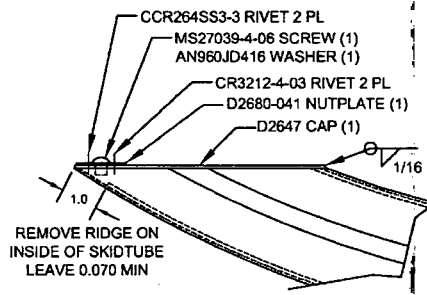


- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE.



**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X  
B4-2  
B4-3  
B4-4  
B4-5

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. CBORE TO Ø0.313 X 0.75 DP



**DETAIL F**  
SCALE NONE  
B8-2  
B8-3  
B8-4  
B8-5





**DETAIL F NOTES:**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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NO. 214

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 52855  
Part number: D206-642-251  
Description: 206 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Dunc Date of Test Coupon 09.10.29

Welder Barclay Elliott Date of Test Coupon 09.10.29

The above named individual is qualified in accordance with AWS D17.1.2001 to weld